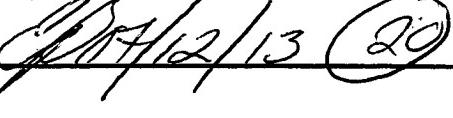


Date: Wednesday, 11/21/2007 12:50:22 PM  
User: Kim Johnston

## **Process Sheet**

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	STRUT ASSEMBLY
Job Number	35930	Part Number	D23241
Estimate Number	10732	Drawing Number	D2324 REV. C
P.O. Number	N/A	Project Number	N/A
This Issue	11/21/2007	S.O. No.	N/A
Prsht Rev.	NC	Type	SMALL /MED FAB
First Issue	N/A	Drawing Revision	C
Previous Run	34291	Material	N/A
Written By		Due Date	12/20/2007
Checked & Approved By	<u>07/11/21</u>	Qty:	20
Comment	Est: E 03.02.28 Reformat; Incorporated D2324-3 & D2324-5 KJ/RF	Um:	Each
<b>Additional Product</b>			
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
1.0	35930A	STOP	
			
Comment: Sub-Component STOP D2324-3 B <u>34291</u>			
2.0	35930B	STRAP	
			
Comment: Sub-Component STRAP D2324-5 B <u>34291</u> (10) 3 35930 (10)			
3.0	AN312A	Bolt	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Bolt <u>M103947</u>			
4.0	AN960JD10	Washer	
			
Comment: Qty.: 4.0000 Each(s)/Unit Total : 80.0000 Each(s) Washer <u>M105792</u>			
5.0	MS21042L3	Nut	
			
Comment: Qty.: 2.0000 Each(s)/Unit Total : 40.0000 Each(s) Nut <u>M105558</u>			
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
			
Comment: SMALL & MEDIUM FAB RESOURCE 1 Assemble as per Dwg D2324.			

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes  No  DQA:  Date: 01/12/14  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 11/21/2007 12:50:22 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STRUT ASSEMBLY

Job Number: 35930

Part Number: D23241

Job Number:



Seq. #: Machine Or Operation:

Description :

7.0 QC5

INSPECT WORK TO CURRENT STEP



S 07/12/13 X20 counts

Comment: INSPECT WORK TO CURRENT STEP

8.0 POWDER COATING

POWDER COATING



M 105914

(20)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

BL

07-12-13

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



31

Comment: INSPECT POWDER COAT

07-12-13 X1

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 203

W

AS 04/12/14

X20

11.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/12/14

Job Completion



U 07.12.14

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

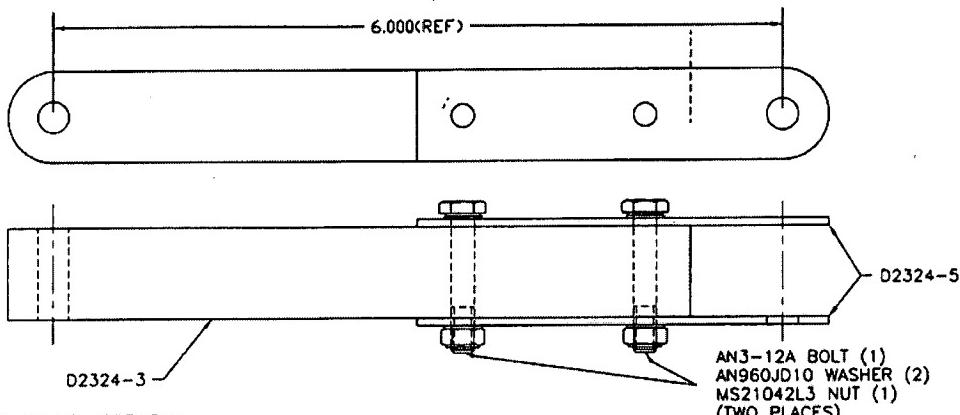
NOTE: Date & initial all entries



DESIGN B. WILLIAMS	DRAWN BY PH	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2324
DATE 04.12.14	TITLE	REV. C SHEET 1 OF 1
		SCALE
		STRUT

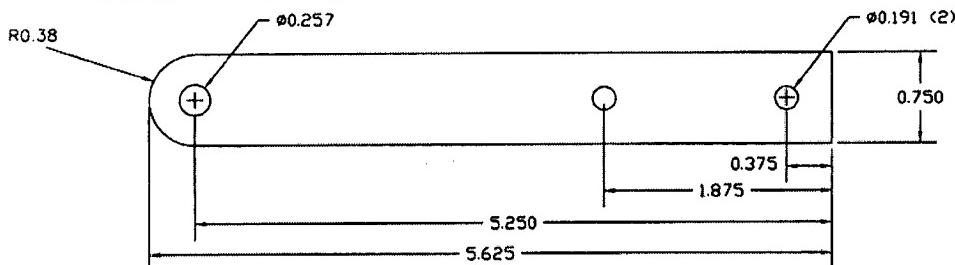
RELEASED

04.12.16 *[Signature]*



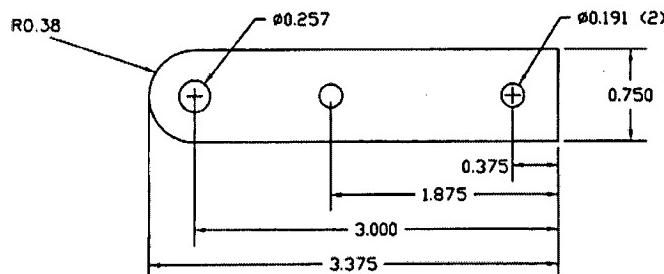
#### D2324 STRUT ASSEMBLY

1) IDENTIFY WITH DART P/N D2324 USING FINE POINT PERMANENT INK MARKER



#### D2324-3

- 1) MATERIAL: 6061-T6/T651 BAR (QQ-A-200/8) 0.75 X 0.75  
(REF DART SPEC. M6061T680.750X00.750)
- 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



#### D2324-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) FINISH: POWDERCOAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *35930*